



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D206-642-541
Job Sheet 200930



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Due Date: 10/18/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D3274-041 REV G IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/18/19		0.00	2.17	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs	10/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
116	QC 10	1 pcs	10/18/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		



Container No: S216643



Part: D206-642-541

Job No: 200930

Serial No/Batch: S216643

Revision: G

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17 JG STC SH98-

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120 Handfinish - 1-1 Chemical-B4B	1 pcs	10/18/19	0.00 0.68	QC 10 - 50	CL
				QC 10 - 58	
				QC 10 - 9	
				Handfinish - 1 - 1 - B4B	BEB19-10-02
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	10/18/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
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						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	MCG TF
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 76	
150 Skidtubes - 2 - B4B	1 pcs	10/18/19	0.00	2.08		Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	
						Skidtubes - 4 - B4B	TF
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
160 QC 5	1 pcs	10/18/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	BE MCG
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
170 Skidtubes - 3 - B4B	1 pcs	10/18/19	0.00	2.17		Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	MCG MCG
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
180 QC 5	1 pcs	10/18/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	BE
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	

						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
190 Skidtubes - 4 - B4B	1 pcs	10/18/19	0.00	2.75	Skidtubes - 1 - B4B		
					Skidtubes - 2 - B4B		
					Skidtubes - 3 - B4B		
					Skidtubes - 4 - B4B		MCC
					Skidtubes - 5 - B4B		TF
					Skidtubes - 6 - B4B		BE
					Skidtubes - 7 - B4B		
200 QC 5	1 pcs	10/18/19	0.00	0.00	QC 5 - 10		
					QC 5 - 12		
					QC 5 - 17		
					QC 5 - 18		
					QC 5 - 19		
					QC 5 - 22		
					QC 5 - 24		
					QC 5 - 3		
					QC 5 - 43		
					QC 5 - 49		
					QC 5 - 51		
					QC 5 - 58		
					QC 5 - 68		OCT 25 2019 DAS 68 9-89
					QC 5 - 9		
					QC 5 - 50		
					QC 5 - 30		
					QC 5 - 40		
					QC 5 - 61		
					QC 5 - 81		
210 QC 10	1 pcs	10/18/19	0.00	0.00	QC 10 - 10		
					QC 10 - 18		
					QC 10 - 24		
					QC 10 - 43		
					QC 10 - 50		
					QC 10 - 58		
					QC 10 - 9		
220 Handfinish - 2-1 Pressure-B4B	1 pcs	10/18/19	0.00	0.45	Handfinish - 2 - 1 - B4B		BE 19-10-25
					Handfinish - 2 - 2 - B4B		
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
230 Spray Paint - 2 - B4B	1 pcs	10/18/19	0.00	0.40	Spray Paint - 1 - B4B		
					Spray Paint - 2 - B4B		RD 19-10-26
					Spray Paint - 3 - B4B		
					Spray Paint - 4 - B4B		
240 QC 14	1 pcs	10/18/19	0.00	0.00	QC 14 - 15		
					QC 14 - 2		
					QC 14 - 34		
					QC 14 - 41		
					QC 14 - 51		
					QC 14 - 58		
					QC 14 - 59		BE 19-10-28

				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
244 Handfinish - 3-1- WingWalk-B4B	1 pcs	10/18/19	0.00 0.50	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	BEB19-10-28
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	10/18/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	ML 14-10-28
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	10/18/19	0.00 0.45	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	BEB19-10-28
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 -	

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260 QC 5	1 pcs	10/18/19	0.00 0.00	B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	10/18/19	0.00 0.68	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
280 QC 5	1 pcs	10/18/19	0.00 0.00	Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	

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					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
290	Packaging 3-1 - Stock - B4B	1 pcs	10/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
295	DC - 1 - B4B	1 pcs	10/18/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
300	QC 21 - FG	1 pcs	10/18/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

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Part Op 110 - (Skid tubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per
 Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod
 Batch: 138989/139011 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274
 and deburr end 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig
 DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of

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skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.
 114 - (QC5- Inspect part completeness to step on W/O)
 116 - (QC10- Inspect visual per QSI004- ground welds)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Skid tubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours)
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Skid tubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Skid tubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274. ****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (QC10- Inspect visual per QSI004- ground welds)
 220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch
 230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5213125
 240 - (QC14- Inspect Spray Paint)
 244 - (Wing Walk as per dwg QSI005 4.4 Batch 5209362)
 246 - (QC3- Inspect Part Finish)
 250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.
 260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts
 270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
 280 - (QC5- Inspect part completeness to step on W/O)
 290 - (Identify as per dwg & Stock Location: _____) Location : FG073
 295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005
 300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	5189763
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5043738
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5191355
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5214176
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5199330
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5099573
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5163230-3
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5216586
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5218780
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5057496
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5197616
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5207076
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	5207779
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5218982
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	F164008
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5200829
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5210726
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5209983
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201005
NAS1149C0332R	Washer (AN960C10L)	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5218154
NAS1149C0463R	Washer (AN960C416)	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5104373

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	5	0
	D3285-1	1	7	0
150-Skidtubes - 2 - B4B	D3282-041	1	3	0
190-Skidtubes - 4 - B4B	D2649	12	83	0
	D3275-1	12	196	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	5,946	0
	CCR264SS3-3	2	55	0
	CR3212-4-03	2	38	0
	D3415-041	1	1	0
270-Handfinish - 4-2-Assembly-B4B	AN3C4A	80	584	0
	AN4C5A	1	70	0
	D2646	1	58	0
	D3413-1	1	19	0
	D3537-1	9	144	0
	D3537-3	1	10	0
	D3672-1	2	1,439	0
	D4956-15	1	7	0
	D4956-23	1	16	0
	D4956-35	1	21	0
	D4956-39	1	9	0
	NAS1149C0332R	80	2,920	0
	NAS1149C0463R	1	205	0
Part Specifications				
Specifications could not be found.				

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Qty	Qty	Part Number	Description
1	1	D2674-041	SKIDTUBE ASSEMBLY
1	1	D2674-043	SKIDTUBE ASSEMBLY
1	1	D2674-044	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D2674-045	SKIDTUBE ASSEMBLY
1	1	D2674-046	SKIDTUBE ASSEMBLY
1	1	D2674-047	SKIDTUBE ASSEMBLY
1	1	D2674-048	SKIDTUBE ASSEMBLY
1	1	D2674-049	SKIDTUBE ASSEMBLY
1	1	D2674-050	SKIDTUBE ASSEMBLY
1	1	D2674-051	SKIDTUBE ASSEMBLY
1	1	D2674-052	SKIDTUBE ASSEMBLY
1	1	D2674-053	SKIDTUBE ASSEMBLY
1	1	D2674-054	SKIDTUBE ASSEMBLY
1	1	D2674-055	SKIDTUBE ASSEMBLY
1	1	D2674-056	SKIDTUBE ASSEMBLY
1	1	D2674-057	SKIDTUBE ASSEMBLY
1	1	D2674-058	SKIDTUBE ASSEMBLY
1	1	D2674-059	SKIDTUBE ASSEMBLY
1	1	D2674-060	SKIDTUBE ASSEMBLY
1	1	D2674-061	SKIDTUBE ASSEMBLY
1	1	D2674-062	SKIDTUBE ASSEMBLY
1	1	D2674-063	SKIDTUBE ASSEMBLY
1	1	D2674-064	SKIDTUBE ASSEMBLY
1	1	D2674-065	SKIDTUBE ASSEMBLY
1	1	D2674-066	SKIDTUBE ASSEMBLY
1	1	D2674-067	SKIDTUBE ASSEMBLY
1	1	D2674-068	SKIDTUBE ASSEMBLY
1	1	D2674-069	SKIDTUBE ASSEMBLY
1	1	D2674-070	SKIDTUBE ASSEMBLY
1	1	D2674-071	SKIDTUBE ASSEMBLY
1	1	D2674-072	SKIDTUBE ASSEMBLY
1	1	D2674-073	SKIDTUBE ASSEMBLY
1	1	D2674-074	SKIDTUBE ASSEMBLY
1	1	D2674-075	SKIDTUBE ASSEMBLY
1	1	D2674-076	SKIDTUBE ASSEMBLY
1	1	D2674-077	SKIDTUBE ASSEMBLY
1	1	D2674-078	SKIDTUBE ASSEMBLY
1	1	D2674-079	SKIDTUBE ASSEMBLY
1	1	D2674-080	SKIDTUBE ASSEMBLY
1	1	D2674-081	SKIDTUBE ASSEMBLY
1	1	D2674-082	SKIDTUBE ASSEMBLY
1	1	D2674-083	SKIDTUBE ASSEMBLY
1	1	D2674-084	SKIDTUBE ASSEMBLY
1	1	D2674-085	SKIDTUBE ASSEMBLY
1	1	D2674-086	SKIDTUBE ASSEMBLY
1	1	D2674-087	SKIDTUBE ASSEMBLY
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1	1	D2674-097	SKIDTUBE ASSEMBLY
1	1	D2674-098	SKIDTUBE ASSEMBLY
1	1	D2674-099	SKIDTUBE ASSEMBLY
1	1	D2674-100	SKIDTUBE ASSEMBLY

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: ON-045
3. TOLERANCES ARE PER DART 081016 UNLESS OTHERWISE NOTED.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES 0.008 TO 0.010 MAX
6. IDENTIFICATION: N/A
7. WEIGHT: FOR 041-049 = 37.5 LBS
8. WELDING TO BE DONE PER PART 081004.
9. ALL HOLES UNLESS OTHERWISE NOTED.
10. THERE SHALL BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT SCUBES UP TO 0.008" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.190" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11. BOND D2674-041 FLOAT WEB INTO D2674-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-251/251 ADHESIVE PER PART 081015. ENSURE HOLES LINE-UP.
12. DRILL 0.257 HOLES FOR ALST-1032-130 INSERTS USING D2674-172 BEFORE FINISH. INSTALL ALST-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-251/251. ON-045, DO NOT DRILL HOLES OR INSTALL INSERTS FOR LONG WEARSHOES.
13. COAT ALL EXPOSED FASTENERS WITH LUBRICANT.
14. ON-045, APPLY COAT OF ROCKGUARD TO SKIDTUBE WHERE WEARPADS ARE INSTALLED.

RELEASED
R 2016-07-26
ECU/16-416

REV.	DESCRIPTION	CP	RF	DATE
G	ADD -045 CONFIGURATION (FOR PH) ZN AG-4, AG-6 REVISE NOTE 2, 7 & 12, ADD NOTE 14 (ZN AG-1)	DS		16.04.25
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IN-0208-942 REV Q	DB		14.04.15
E	REVISE NOTE 2: FINISH NOW PRIMER/PAINT WAS POWDERCOAT, REF: PAR13-266	DW		13.06.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP		08.12.19
C	ADD -043: NEW INSERTS	CP		05.03.18
B	MOVE SADDLE HOLE: 42-14 WAS 42.78	CP		04.08.09
A	NEW ISSUE	CP		04.03.15
DESIGN	CP	RF		
DRAWN				
CHECKED	AK			
MFG. APPR	JLM			
APPROVED	DS			
DE APPR				
DATE	16.04.25			
DART AEROSPACE USA, INC				
EUGENE, OR				
DRAWING NO. D3274				
REV. G				
SHEET 1 OF 5				
SCALE				
NTS				
SKIDTUBE ASSEMBLY				
COPYRIGHT © 2016 BY DART AEROSPACE USA, INC				
THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION THAT IS EXCLUDED FROM PUBLIC RELEASE UNDER E.O. 13526				

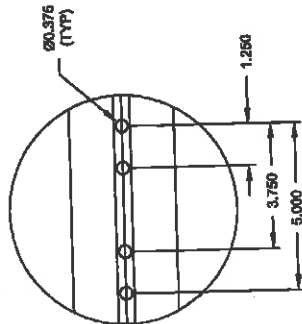
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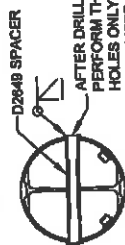
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2016-07-26

DETAIL A: DRILL DETAIL
D4-4, D4-4, D4-4, D4-4



DETAIL B
B4-4, B4-4

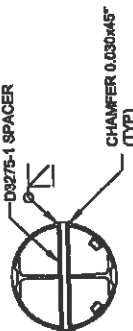
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2848 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C
C4-4, C4-4

FOR Ø0.313 HOLES ONLY



DETAIL D
A4-4, A4-4



ALST-1032-130 INSERT (1)
ANSCA BOLT (1)
NAS1148C0332R WASHER (1)
(78 PLACES)
WEARSHOE/WEARPAD (REF) /G

DETAIL F: END FINISHING DETAIL
B7-2, B7-3

ANSCA BOLT (1)
NAS1148C0332R WASHER (1)
INSTALL WITH SIKAFLEX-241-291
CR3212-4-03 RIVETS (2 PLACES)
D3415-041 NUT PLATE,
LPS HARDCOAT ON EXTERIOR
D3413-1 RING
D3285-1 CAP (REF)
1/16
1.0
REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.
ORIENTATION
OF D3415-041
CCR2848S3-3 RIVETS (2 PLACES)

DETAIL E
E4-4, E4-4

ANSCA BOLT (1)
NAS1148C0332R WASHER (1)
D3672-1 WASHER (1)
INSTALL WITH SIKAFLEX-241-291
D2848 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE
Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2848 CAP
BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART C81 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____